

Page 1

Tuesday, March 17, 2015 11:51:44 AM

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, March 17, 2015 11:51:45 AM

130606

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Support Turning Detail

Start Date: 3/17/2015 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 3/17/2015 **Req'd Qty:** 8.00 ***g***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

MF

15-4-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 1

Work Order ID: 130606

130606

Parent Item: D4909-1TRN

D4909-1TRN

Parent Item Name: Support Turning Detail

Start Date: 3/17/2015

Required Date: 3/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	0.0000	1	8	DAS 25 9-89	15-4-13	
D6104-011										**			
17-4 SS Roundbar 6.50"OD													

130691

X 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART AEROSPACE LTD		Work Order: 130606
Description: Turning Detail for D4909-1		Part Number: D4909-1TRN
Inspection Dwg: D4909	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Milling Section								
A-A	3.268	3.288		3.281	3.285	3.284	3.282	3.282
B-B	1.250	1.270		1.250	1.254	1.255	1.256	1.255
C-C	3.990	4.010		3.996	4.000	4.000	4.000	4.000
D-D	0.718	0.738		.728	.728	.728	.728	.728
E-E	0.150	0.170		.159	.156	.156	.156	.157
F-F	0.090	0.110		.098	.097	.095	.099	.097
G-G	0.090	0.110		.099	.099	.099	.099	.099
H-H	R0.022	R0.042		.032	.032	.032	.032	.032
I-I	R0.240	R0.260		.250	.250	.250	.250	.250
J-J								
K-K								
L-L								
M-M								
N-N								
O-O								
P-P								

Measured by: SL	Date: 15-4-13
Audited by: JFC	Date: 2015-04-14
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.07	New Issue	KJ	

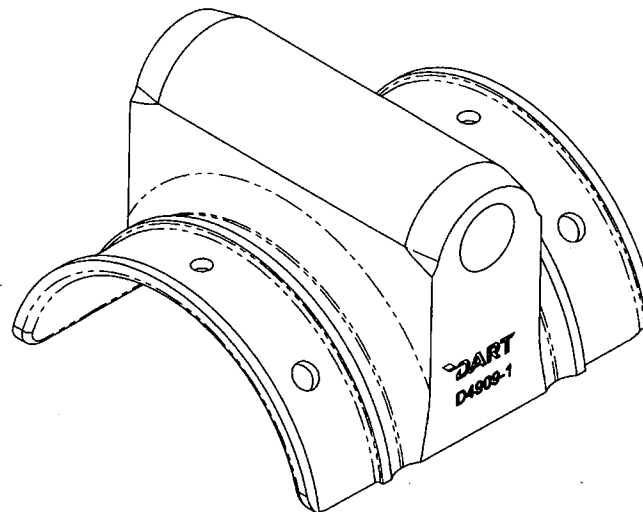
DART AEROSPACE LTD		Work Order: 130606
Description: Turning Detail for D4909-1		Part Number: D4909-1TRN
Inspection Dwg: D4909	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/6	2/4	3/8	4	5
Milling Section								
A-A	3.268	3.288		3.283	3.283	3.283		
B-B	1.250	1.270		1.255	1.255	1.255		
C-C	3.990	4.010		4.001	4.000	4.000		
D-D	0.718	0.738		.728	.728	.728		
E-E	0.150	0.170		.156	.157	.157		
F-F	0.090	0.110		.098	.098	.098		
G-G	0.090	0.110		.099	.099	.099		
H-H	R0.022	R0.042		.032	.032	.032		
I-I	R0.240	R0.260		.250	.250	.250		
J-J								
K-K								
L-L								
M-M								
N-N								
O-O								
P-P								

Measured by: SL	Date: 15-4-13
Audited by: OFC	Date: 2015-04-14
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.07	New Issue	KJ	



D4909-1 SUPPORT

NOTES:

- 1) MATERIAL: MAKE FROM D4909-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D4909-1" IN INDICATED AREA
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.90 lbs

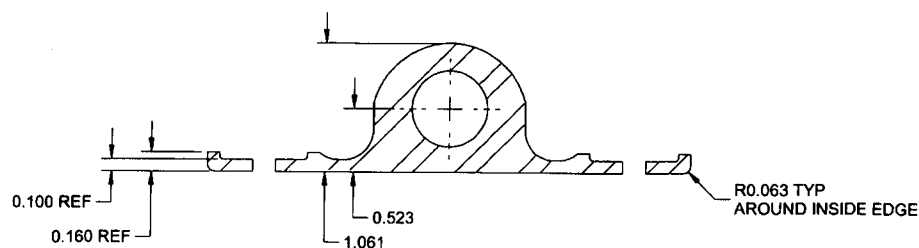
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ALL INFORMATION IS IN THE
PUBLIC DOMAIN
NO. 130606 MLS
15-03-17

RELEASED
2013-08-06
WJ

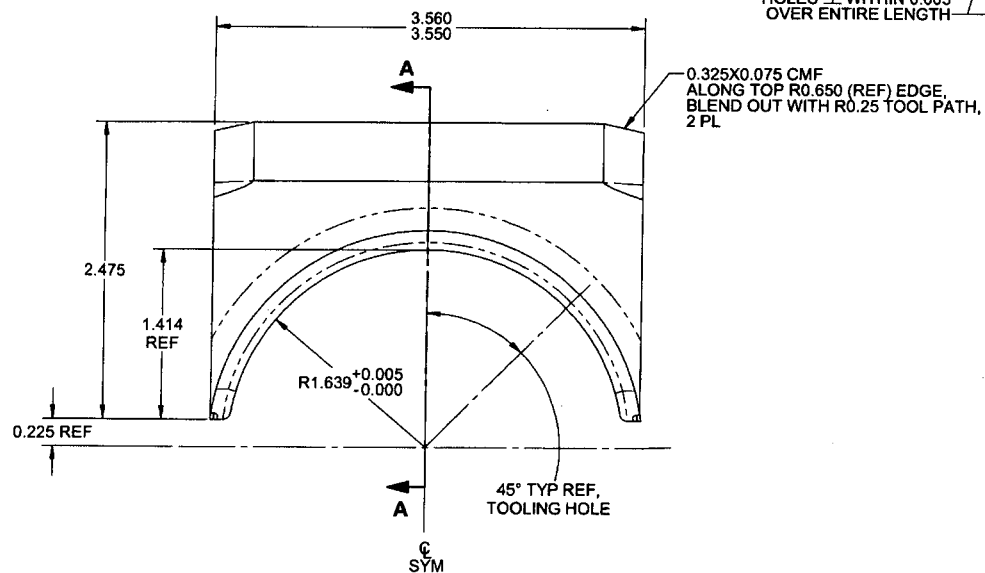
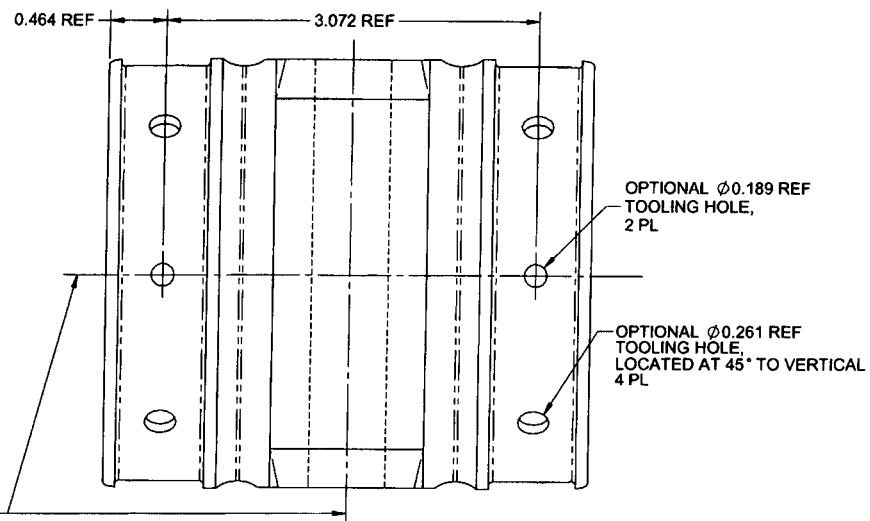
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.04.08		

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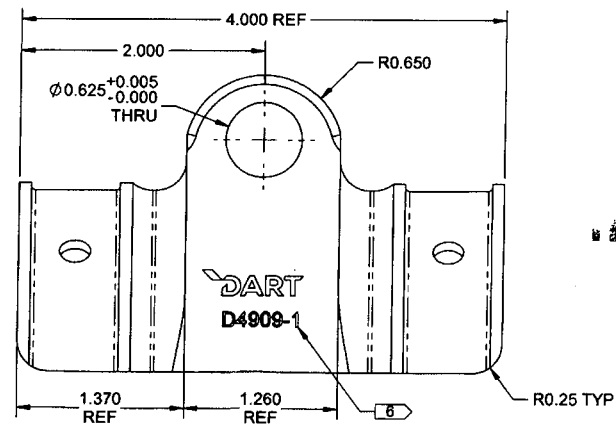
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SECTION A-A
SCALE 1X



D4909-1 SUPPORT



RELEASED
2013-08-06

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4909	REV. A
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APPROVED		TITLE SUPPORT	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

